

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029415**Date Inspected:** 15-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) Joe Adame was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

In Process Visual Inspection

RWR 201304-007, 201304-006

QA observed at random intervals, ABF/JV welder Chris Bruce #8981 performing carbon arc air gouging of ESW welds for defect removal on ESW weld designated as N. Location of excavation was noted as:

Face B

Y= 2080mm, 2240mm

L= 160mm

W= 40mm

D= 46mm

After excavation and grinding to bright metal ABF Quality Control (QC) Inspector Bernie Docena was observed performing MT testing of the excavation to ensure all discontinuities were removed prior to welding. Mr. Docena and the QA Inspector also performed a UT verification of HAZ areas located 300 mm above and below of the excavated to be reinspected after welding. See TL-6027 for additional information on items inspected on this date.

In Process Visual Inspection

RWR 201208-007

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA observed at random intervals, ABF/JV welder Mike Jimenez #4671 performing carbon arc air gouging of ESW welds for defect removal on ESW weld designated as G. Location of excavation was noted as:

Face A

Y= 3100mm (original), 3070-3350 (new)

L= 280mm

W= 40mm

D= 45mm

After excavation and grinding to bright metal ABF Quality Control (QC) Inspector Bernie Docena was observed performing MT testing of the excavation to ensure all discontinuities were removed prior to welding. Mr. Docena and the QA Inspector also performed a UT verification of HAZ areas located 300 mm above and below of the excavated to be reinspected after welding. See TL-6027 for additional information and recordable indications observed on this date.

Ultrasonic Testing of ESW

ESW N, Face A:

This QA performed continued Ultrasonic Testing (UT) on approximately 1000mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW N" face A. Location (Y=7840) of this weld was inspected using this testing method. No recordable indications were observed at the time of testing. QA performed UT of weld designated as "ESW N" in accordance with the approved supplemental procedure for confirmation and evaluation of planar & transverse defects. Tandem report for work performed on this date will be completed by QC technician and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. Please see TL-6027 for information on items inspected on this date.

Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to testing and work performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Adame,Joe	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
